



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

SO53106

RBST4241-5
Job Sheet 170734



Part No: RBST4241-5

Job Qty: 3 ea

Part Name: Roller



DAS
13
9-89

MAR 12 2018

Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/19/18

Job Tracking No:

Due Date: 1/31/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: RBST4241 REV.1 IPP REV:A 18.01.17 NEW ISSUE DD VERF:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Outsource	3 pcs		1/31/18	0.00	0.00	Outsource16		AT 18/02/18
110	Packaging	3 pcs		1/31/18	0.00	0.00	Packaging2		AT 18/03/18
120	QC	3 pcs		1/31/18	0.00	0.00	QC6		38
130	Packaging	3 pcs		1/31/18	0.00	0.00	Packaging3-2		18/03/2018
140	QC21-SA	3 Ea		1/31/18	0.00	0.00	QC21		GA 13

Part Op 100 - ISSUE P/O: 039207 TO KG GRINDING. MANUFACTURE AS PER DWG. SHIP QTY REQUIRED OF
Descriptions: 89031009

DAS
21
9-89

MAR 27 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
89031009	TBD	3 (1 ea)	100-Outsource	SO45010

①

SO46525

Part Specifications

Specifications could not be found.

Plex 1/19/18 7:01 AM Dart.lajeunesse.marie

start up

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



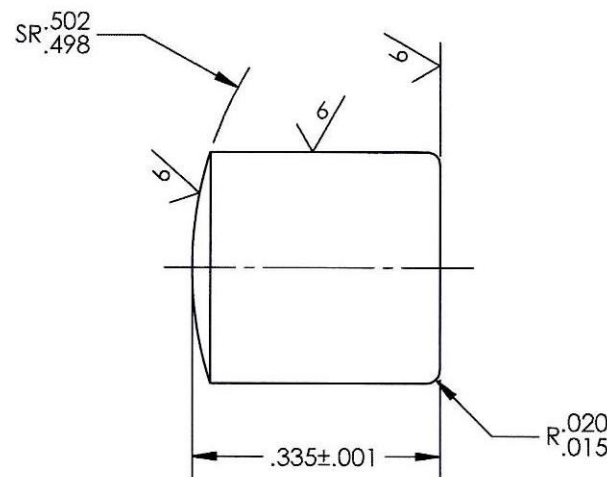
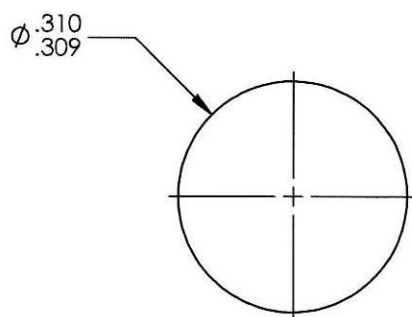
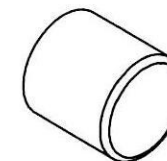
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																																																																	
Date : _____	Step #: _____	Job No: 170734 Mfg Date: 03/20/18 Packaging Operation: Revision: Serial No/Batch: S053106 PART NO: RBST4241-5 Roller			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																																																														
Description V 																																																																																																			
Root Cause <table style="width:100%; border-collapse: collapse;"> <tr> <td style="width:50%; vertical-align: top;"> <table style="width:100%; border-collapse: collapse;"> <tr><td>Environment</td><td>☐</td></tr> <tr><td>Design</td><td>☐</td></tr> <tr><td>Doc/Data</td><td>☐</td></tr> <tr><td>Equip/Tooling</td><td>☐</td></tr> <tr><td>Handling/Pre</td><td>☐</td></tr> <tr><td>Material</td><td>☐</td></tr> <tr><td>Internal Transport</td><td>☐</td></tr> <tr><td>Tribal Knowledge</td><td>☐</td></tr> <tr><td>LOA</td><td>☐</td></tr> <tr><td>Substation</td><td>☐</td></tr> <tr><td>Past Expiry Date</td><td>☐</td></tr> <tr><td>Misidentified</td><td>☐</td></tr> </table> </td> <td style="width:50%; vertical-align: top;"> <table style="width:100%; border-collapse: collapse;"> <tr><td>No Re-verification</td><td>☐</td></tr> <tr><td>Operator</td><td>☐</td></tr> <tr><td>Offset/Setup</td><td>☐</td></tr> <tr><td>Supplier</td><td>☐</td></tr> <tr><td>Training</td><td>☐</td></tr> <tr><td>Use for Testing</td><td>☐</td></tr> <tr><td>Poor Information</td><td>☐</td></tr> <tr><td>Rushing</td><td>☐</td></tr> <tr><td>Product Improvement</td><td>☐</td></tr> <tr><td>Process Improvement</td><td>☐</td></tr> <tr><td>Manufacturing Process</td><td>☐</td></tr> <tr><td>Past Due</td><td>☐</td></tr> </table> </td> </tr> </table>		<table style="width:100%; 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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 170734 WLS
1801-19

(5)
ROLLER

DART AEROSPACE	
TITLE DRILL PRESS SWAGING TOOL	
DWG NO. RBST4241-5	REV 1
MAT'L STEEL	UNLESS OTHERWISE SPECIFIED
HEAT TREAT RC 55-60	DIMENSIONS ARE IN INCHES
FINISH	.XXX ± .005 FRACTIONS ± 1/8
SPEC	.XX ± .01 ANGLES ± 5°
	.X ± .1 SURFACES = 125/✓
DRAWN BY: DD 04/05/2017	1. BREAK ALL SHARP EDGES
CHECKED: SM 04/05/2017	.015 x 45° OR .015R
OPPS APPR: AA 04/05/2017	2. DIMENSIONAL LIMITS APPLY
QA APPR: JL 04/05/2017	AFTER PLATING
APPROVED: JAG 04/06/2017	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
SCALE 4:1	USED ON MODEL
DATE 4/5/2017	SHEET 4 OF 9

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO039202

Supplier: AFF001-VC
Affutage K.G. Inc.
11455 Philippe Panneton Ave.
Montreal
QC
H1E 4M1 Canada
Phone: 514 323 0192 514 323 6631
Fax: 514 323 6631

PO No: PO039202

PO Date: 3/5/18

Due Date: 3/14/18

**Purchase Order
Revision:**

Revision Date:

Ship-To Contact: Lavoie, Chantal
Phone: clavoie@dartaero.com

REVISED

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground

Pymt Terms: Net 30

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	170734	RBST4241-5	Roller ISSUE P/O: _____ TO KG GRINDING. MANUFACTURE AS PER DWG. SHIP QTY REQUIRED OF 89031009	Firmed	3/14/18	6 pcs	0 pcs	6 pcs	\$12.00/pcs	\$72.00
						<i>6x</i>		<i>AT</i>		
2	173095	RBST2854-5	Roller ISSUE P/O: _____ TO KG GRINDING. MANUFACTURE AS PER DWG. SHIP QTY REQUIRED OF 89031009 1 pin make 4 pcs	Firmed	3/14/18	26 pcs	0 pcs	26 pcs	\$12.00/pcs	\$312.00
						<i>26x</i>				
3	170733	RBST1016-5	Roller ISSUE P/O: _____ TO KG GRINDING. MANUFACTURE AS PER DWG. SHIP QTY REQUIRED OF 89031009	Firmed	3/14/18	6 pcs	0 pcs	6 pcs	\$12.00/pcs	\$72.00
						<i>6x</i>				
4	171045	RBST1007-5	Roller ISSUE P/O: _____ TO KG GRINDING. MANUFACTURE AS PER DWG. SHIP QTY REQUIRED OF 89031009 1 pin make 3 pcs	Firmed	3/14/18	6 pcs	0 pcs	6 pcs	\$12.00/pcs	\$72.00
						<i>6x</i>				
5	RB KIT 407M-09		Gauge Pin 1-Issue P/O to KG Grinding; P/O _____ (Ship quantity req'd: 1 vial makes 4 pins) 2-Grind as per DWG. 3- Certificate of Conformity is required	Firmed	3/14/18	3 pcs	0 pcs	3 pcs	\$12.00/pcs	\$36.00
						<i>3x</i>				

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7-88*

AFFUTAGE K.G. INC. K.G. GRINDING INC.

40 ans
Depuis 1975

11455 Ave. Philippe Panneton
Montréal, Québec
Canada, H1E 4M1
Tél. : 514-323-0192
Fax : 514-323-6631

Distributeur d'outils de coupe & Affutage sur mesure

Distributor of cutting tools & Custom tooling

BON DE LIVRAISON DELIVERY SLIP

DATE: MAR-14-2018

DART AEROSPACE

73005

P.O.# 39202

QTÉ	LIVRÉE	B/O	DESCRIPTION	PRIX UNITAIRE	TOTAL
6	(6)	-	RBST4241-5		
26	(26)	-	RBST2854-5		
6	(6)	-	RBST1016-5		
6	(6)	-	RBST1007-5		
3	(36)	-	BB KIT 407M-09		
3	(36)	-	" " - 07		
3	(36)	-	" " - 15		
6	(67)	-	" " - 23		
4	(4)	-	" " - 21		
3	(36)	-	" " - 05		
3	(36)	-	" " - 11		
2	(2)	-	" " - 17		
				SOUS-TOTAL	
				TPS	
				TVQ	
				TOTAL:	

REÇU EN BONNE CONDITION / RECEIVED IN GOOD ORDER

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